Ly Tuestry April 8 \*115163\*

Work Order ID	1	151	63
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Monday, March 17, 2014 2:49:21 PM

Page 1

Item ID: Revision ID:	D3574-2		Accept	*N900	<u>040</u>	100	)*	Setup	Start	*N	S1*
Item Name:	Cabin Floor Protector			<u> </u>					Stop	*/\!	S2*
Start Date: Required Date:	3/17/14 <b>Start Qty:</b> 1.00 <b>Req'd Qty:</b> 1.00	■		Cust Item	ID:						
Reference:											
Approvals:	Process Plan:	Date: 14-03-19	Tooling: _	D	ate:			Run	Start	~!\	R1*
	QC:	Date:	<b>SPC</b> (Y/N):	<b>D</b>	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejo		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			÷							
D3574	Rev B										
100	-	<del></del>	0.00	!							· · · · · · · · · · · · · · · · · · ·
*100* Waterjet	FLOW WATER JET  Memo		0.00	I					<u> </u>		Jm14-04-8
FLOW CNC Waterj	jet 1-Cut as	per Dwg D3574									
		v: <u> </u>		:							
	2-Debur	г		,							
110	QC2- Inspect parts o	ff machine FAI/FAIB	0.00	!							
*110* QC Quality Control	Memo		0.00				_1_	0			Jm14-04-8

DQA:			Date:						NAANGE / 115	ND 4 TF				"DART
QA Closed:			Date:			WORK ORDER NON-	٠. ( (	JNFOI	RIMANCE / UF		ork Order up	odate only	$\neg$	AEROSPACE
Work Orde	r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	•	
Part N	o					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	Т				Desc	ription of work order update	- 1	nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng	Descri		Date	Verification	ı	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
			<u>-</u> -			<del></del>	FA	ULT CAT	regory					<del></del>
Landin		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea nspection	n Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread	ion Incomplete/Un ions Incomplete/U gned/off center eled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	$\neg$	Wave/Tw	ist in Tub	e		Fit/Function	Г	Out of S	Sequence		<del> </del>			

Work Order ID 115163 \*115163\* Page 2 Monday, March 17, 2014 2:49:21 PM D3574-2 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Stop Cabin Floor Protector **Item Name:** \*1\* Start Qty: 1.00 **Start Date:** 3/17/14 **Cust Item ID:** Required Date: 3/17/14 Req'd Qty: 1.00 \*1\* **Customer:** Reference: Start Run Process Plan: \_\_\_\_\_ Date: **Approvals: Tooling:** Date: Stop QC: \_\_\_\_ Date: SPC (Y/N): Date: Tool ID Sequence ID/ Operation Set Up/ Tool# Plan Reject Reject Accept Insp. **Work Center ID** Description Qty Qty Number Stamp Code **Run Hours** 0.00 120 QC8- Inspect parts - second check DAS \*120\* 27 QC 0.00Memo Quality Control

130 0.00 Small Fab \*120\* 0.00 Small Fab Merko Small Fab Deburrif necessary. DAS QC5- Inspect part completeness to step on W/O 0.00 140 \*140\* OC 0.00 Memo **Quality Control** 

DQA:			Date:											$^{\mathcal{L}}$ aaa $\mathbb{C}^{\mathcal{L}}$
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UP	DATE				AEROSPACE
QA Closed:			Date:								Vork Order	update only		
Work Orde	r:					DISPOSITION				AGAINST [	EPARTMEN	T/PROCESS		
Work Orac	-					Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	P	rod. Eng. Coor.	H	Quality
	•					Use-as-is			noforming	Finishing		ore/Packaging	П	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier	-	
Root					Desci	ription of work order update		nitial	Actio		Sign &			
Cause	4	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector
Design	_			:										
Doc/Data														
Equip/Tooling	$\dashv$													
Handling/Pre	$\dashv$													
Material	$\dashv$						ļ							
Operator Offset/Setup	-													
Process	$\dashv$													
Supplier	_		•											
Training	_						ļ							
Transport	$\dashv$												1	
Unapproved														
							FA	ULT CA	TEGORY			•		
Landi	ng G	ìear				General		_						
		Bending				Bend		Folio/F	Program		Outside D	mensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		. [	Over/Und	er tolerance	Ш	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incor	reci	Ш	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u></u>	Inspect	ion Incomplete/Und	qualified	Part Lost/	Missing	Ш	Weld
	_	Cuffs				Contamination	_	4	tions Incomplete/U	nclear	Part Move		Ш	Wrong Stock Pulled
		Crushing				Countersink	_	• `	gned/off center	L	Positioned	_		
	-	Heat Trea				Cut Too Short		Mislabe			Power Los	s/Surge	Ш	Other
		Inspectio	•	Tube		Drawing		Misrea						
	$\overline{}$	Marks/Ch			<u> </u>	Drill Holes	_	Off-set						
		Turning S	•		$\vdash$	Finish		4	Calibration					
[ ]		Wave/Tw	vist in Tub	e		Fit/Function	1	Out of	Sequence					

## \*115163\*

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Monday, March	17, 2014 2:	49:21 PM									
Item ID: Revision ID:	D3574-2			Accept	*N900	040	100*	Setup	Start	*N!	S1*
Item Name:	Cabin Floor I	Protector			1				Stop	*N!	S2*
Start Date:	3/17/14	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	3/17/14	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>						
Reference:			•		!						
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		Run	Start	*NI	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	*N!	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID			ccept Re		Reject Number	Insp. Stamp
150		Identify as per dwg & St		0.00				1 /	( 4		DAS
*150* Packaging		Memo	PM15085	0.00				17/7/	<u>'7</u> (		DAS <u>32</u> 9-89
Packaging					;						
160		QC21- Final Inspection	- Work Order Release	0.00	!						,
*160*		Memo		0.00			_	Wr2		0-40	<b></b>
Quality Control		Azento			,				Mc	エリ	04-08

DQA:		Date:											TRACT
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		W	ork Order up	odate only	AEROSPACE
					DISPOSITION						PARTMENT		<u> </u>
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTIVICINI,	/PROCESS	
Part N					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo		<del></del>	<del></del>	Suspected Unapproved			Large Fab	Composite			Supplier	
Root				Desci	ription of work order update		nitial	Áct	ion		Sign &		
Cause	Date	e Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
Design													
Doc/Data		1	ļ										
Equip/Tooling													
Handling/Pre						İ					*		
Material													'
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport	<b>-</b>												
Unapproved													
						FA	ULT CA	regory			•	•	
Landir	ng Gear				General	-							
	Bendi	ng			Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
ĺ	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorre	ci	Temperature/Cure
	Crimp	/Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified		Part Lost/M	issing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/L	Inclear		Part Moved		Wrong Stock Pulled
	Crush	ng			Countersink		Misalig	ned/off center			Positioned V	ــــــ Vrong	_
	Heat 1	reat			Cut Too Short		Mislabe				Power Loss/		Other
İ	Insped	tion Strip ir	Tube		Drawing	Г	Misrea	d			•		
	_	/Chatter			Drill Holes		Off-set						
	Turnir	g Sequence	<b>:</b>		Finish		Out of	Calibration					
	Wave	Twist in Tu	be		Fit/Function		Out of	Sequence					

**Picklist Print** 

Monday, March 17, 2014 2:49:20 PM

Work Order ID: 115163

\*115163\*

**Parent Item:** 

D3574-2

\*D3574-2\*

Parent Item Name: Cabin Floor Protector

**Start Date:** 3/17/14

Required Date: 3/17/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Qty po Hand	per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,964.990	(	26)			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
*MI FXS 1	25-F60	029-04	*					**				Tmi	4-04-6

\*MI FXS 125-F60029-04\*
GE PLASTICS LEXAN SHEET

Location	Loc Oty	Loc Code	
MAT019	1964.99		
124866	106		
m126425	467.99		
m127934	1391		127934

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Ord	er:				:	DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
	• • •					Rework			Skid-tube	Crosstube	7	Water Jet		Engineering
Part !	Vo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging		Other
NCR I	Vo.					Suspected Unapproved			Large Fab	Composite	J	Supplier		
Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verificatio	า	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator	-					•								
Offset/Setup Process	$\vdash$													
Supplier	<u> </u>													
Training	$\vdash$		1											
Transport	H													
Unapproved														·
	•	<u> </u>	<del></del>	* <del></del>	4		FA	ULT CA	TEGORY					
Landi	ng (	Gear				General								
		Bending				Bend		Folio/	Program		Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ci		Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing		Weld
	<u></u>	Cuffs				Contamination		4	tions Incomplete/l	Jnclear	Part Moved			Wrong Stock Pulled
	<u></u>	Crushing				Countersink		- 1	gned/off center	<u> </u>	Positioned V	· ·		1
	_	Heat Tre			L	Cut Too Short	<u></u>	Mislab			Power Loss/	Surge		Other
	_	4 '	on Strip in	Tube	$\vdash$	Drawing	<u> </u>	Misrea						
		Marks/Cl			<u> </u>	Drill Holes	<u> </u>	Off-set						
		1	Sequence		_	Finish	<u></u>	4	Calibration					
		Wave/Tv	vist in Tub	ре		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	115163
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	
Ø3.00	+0.006/-0.001	3.003	_		J	Themos
7.37	+/-0.030	7.37	_		U	
10.75	+/-0.030	10.75	_		V	14m08
11.00	+/-0.030	11.00	-		ν	
15.25	+/-0.030	15.25	_		T	Thomas .
25.87	+/-0.030	25.87"	_		工	
39.75	+/-0.030	39.75	_		Τ	
44.75	+/-0.030	44-75	-		T	
53.51	+/-0.030	53.51"	_		7	
63.50	+/-0.030	63.50	_		7	
65.25	+/-0.030	45.25	_		T	
10.75	+/-0.030	10.75	-		V	
11.00	+/-0.030	11.000	-		ν	
14.75	+/-0.030	14-35-			7	
25.50	+/-0.030	25.50			1	
25.75	+/-0.030	25.75	_		1	
26.00	+/-0.030	26.00	_			
32.87	+/-0.030	32.87	-		T	
38.81	+/-0.030	38.81°			T	
45.00	+/-0.030	45,000	_		T	
48.25	+/-0.030	48-25	-		τ	
58.38	+/-0.030	56.36	_		T	
61.25	+/-0.030	61.25	_		T	
64.13	+/-0.030	64.13	_		7	
64.63	+/-0.030	64.63	-		†	
66.50	+/-0.030	66.50			1	
7.50	+/-0.030	7.50	_		r	
9.50	+/-0.030	9.50-	-		V	
10.38	+/-0.030	10.38	_		ν	
10.88	+/-0.030	10.99*			V	
14.50	+/-0.030	14.504	-		T	-
16.56	+/-0.030	16.56	_		4	
18.75	+/-0.030	18.75	_		T	
24.13	+/-0.030	24.13"	_		1	

DART AEROSPACE LTD	Work Order:	
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.500			T	
30.50	+/-0.030	30 50	_		T	
33.88	+/-0.030	33.882			T	
39.50	+/-0.030	39.50"	-		<u> </u>	
40.25	+/-0.030	40-25	-		て	
43.50	+/-0.030	43.50			T	
46.60	+/-0.030	46.60°			Τ	
						<u> </u>
7.63	+/-0.030	7.63			υ	
11.00	+/-0.030	11.00	_		V	
11.50	+/-0.030	11.50	_		V	
16.75	+/-0.030	16.75	_		丁	
19.00	+/-0.030	19.000			Τ	
22.50	+/-0.030	22.50			1	
30.75	+/-0.030	30.75			T	
32.63	+/-0.030	30.63			Τ	
32.75	+/-0.030	3375			T	
35.13	+/-0.030	35.13			T	
36.50	+/-0.030	36.00	_		<u> </u>	
40.00	+/-0.030	40-00			て	
41.88	+/-0.030	4.860	-		Т	
43.63	+/-0.030	43.63			T	
0.125	+/-0.010	0.125	- AS		V	

Measured by: 7m	Audited b	y: 27	Prototype Approval:	N/A
Date: (4-02	1-8 Dat	e: 14148	Date:	N/A

Rev	Date	Change	Revised by	Approved
Δ	08.02.28	New Issue	KJ//DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
<u> </u>		Dimensions updated per Dwg Rev B	KJ 🚧	
C	09.05.15	Dimensions updated per Dwg Rev B		<del>- 13</del> 7

16.75 11.50 22.50 19.00 RFF 7.37 10.75 11.00 11.00 15.25 14.75 25.50 25.75 25.87 R1.50 26.00 2 PL 32.87 R200.0 ----38.81 39.75 -44.75 44.75 45.00 B 1.75 49.11 48.25 53.51 Ø3.00 58.38 TYP 61.25 63.50 64.13 64,63 65.25 0.125 REF 66.50 R0.25 30.50 26.50 **D3574-1 CABIN FLOOR PROTECTOR** 

0

115163 MP 14-03-19

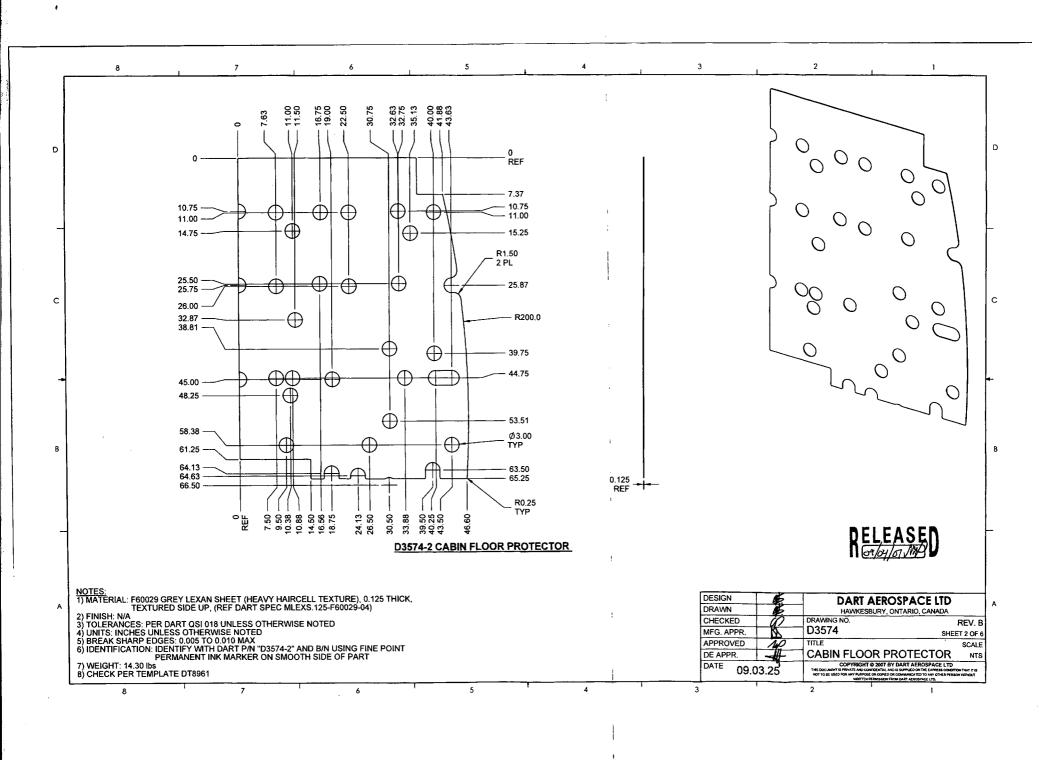
NOTES: 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

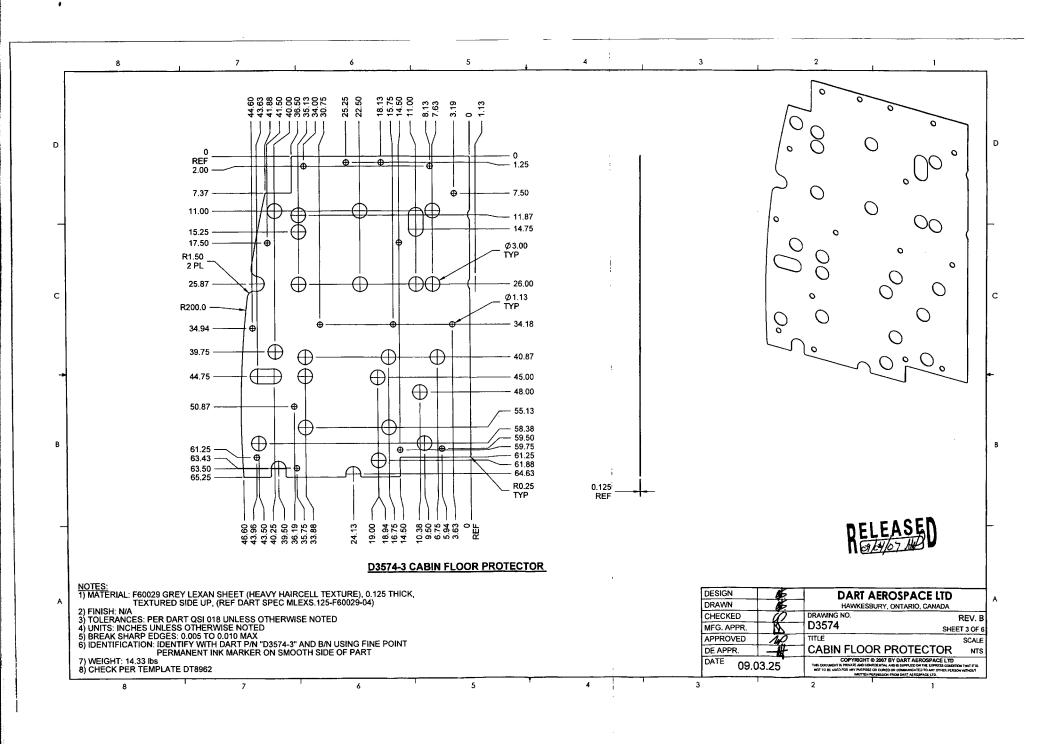
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961

В	ADD CU PLATE	Л-ОUТ ТО -1/- ZN B7-1, B8-5;	5 FOR WEIGHT AND BALANCE DATA -2 NOW SHOWN ON SHEET 2	09.03.25	
Α	NEW IS	SUE	CB 07.06		07.06.08
REV.			DESCRIPTION BY DATE		DATE
DESIG	ν	<b>6</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		D
DRAW	V	15			Α
CHECK	ŒD	00	DRAWING NO.		REV. B
MFG. A	PPR.	187	D3574	5	SHEET 1 OF 6
APPRO	VED _	10	TITLE		SCALE
DE API	PR.	-44-	CABIN FLOOR PROT	ECTO	R NTS

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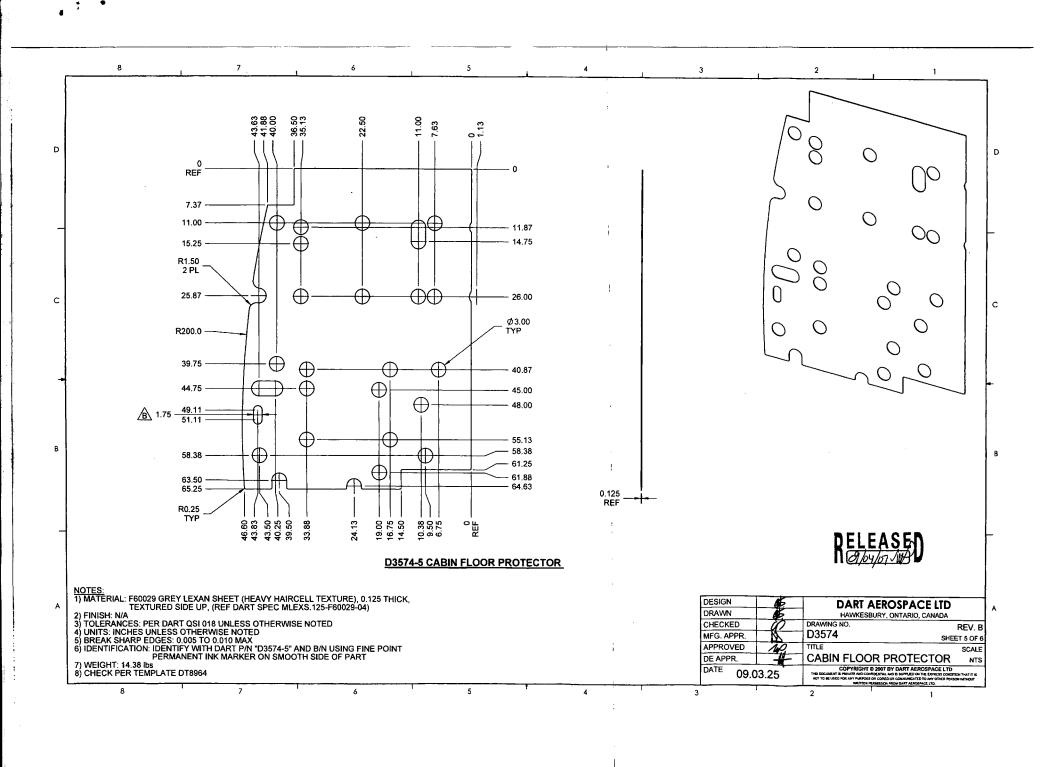
0 11.13 3.13 3.13 7.63 8.13 11.00 14.50 22.10 22.50 22.50 22.50 22.50 22.50 22.50 D 0 REF 1.25 2.00 7.37 7.62 10.25 11.00 11.87 14.75 - 15.25 Φ-17.62 Ø3.00 TYP 25.87 26.00 С R1.50 Ø1.13 TYP 2 PL 34.25 34.13 - 34.94 39.75 40.87 -45.00 44.75 48.00 -51.00 R200.0 55.13 -59.50 58.38 59.75 61.25 61.25 63.43 61.88 - 63.50 64.63 65.25 0.125 R0.25 REF TYP 88.888.888.88 **D3574-4 CABIN FLOOR PROTECTOR** NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7

8

7) WEIGHT: 14.18 lbs 8) CHECK PER TEMPLATE DT8963

DATE 09.0	03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD.  THIS DOCUMENT OF PRINT, WHO COMPOSITION, AND IS UPPRINTED ON THE EXPRESS CONTROL THAT IT IS NOT TO BE USED FOR ANY PAPERS OR COPED OR COMMANDATED TO ANY OTHER PERSON WITHOUT WAITTEN PERSONSHIP FROM DART ARROPATED.		
DE APPR.	#	CABIN FLOOR PROTECTOR	NTS	
APPROVED	NO		CALE	
MFG. APPR.	<i>SS</i>	D3574 SHEET 4	OF 6	
CHECKED	in		V.B	
DRAWN	<b>A</b> .	HAWKESBURY, ONTARIO, CANADA		
DESIGN	<del></del>			



22.10 22.50 24.50 35.13 36.50 40.00 41.88 43.63 11.00 D ŘEF 7.37 10.25 11.00 11.87 14.75 15.25 26.00 25.87 С R1.50 2 PL Ø3.00 TYP  $\oplus$ 39.75 40.87 -44.75 45.00 48.00 -- R200.0 55.13 -1 58.38 61.25 61.88 63.50 64.63 65.25 0.125 R0.25 REF TYP RFO 6.75 9.50 10.38 14.50 16.75 18.94 19.00 39.50 40.25 43.50 46.60 1 **D3574-6 CABIN FLOOR PROTECTOR** NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) DESIGN DART AEROSPACE LTD 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3574 MFG. APPR.

7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965

8

6

3

DATE 09.03.25

TITLE

APPROVED

DE APPR.

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HEAT IS PRIVATE AND COMPONENTAL AND IS SUPPLIED ON THE EXPRESS CONCIDENT THAT IT IS

NTS

**CABIN FLOOR PROTECTOR** 

SCALE

SHEET 6 OF 6